

# Work Order ID 50496

July 10, 2009 2:45:35 PM



Page 1

Item ID: D3831-2KIV  
Revision ID: A-PROTO  
Item Name: Rear Overhead, RH

Accept



Setup Start



Stop



Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF Date: 09-07-10 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3831	A-PROTO 09.06.12

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

BB 09/07/13 X1  
M109703

110

0.00



Thermoform

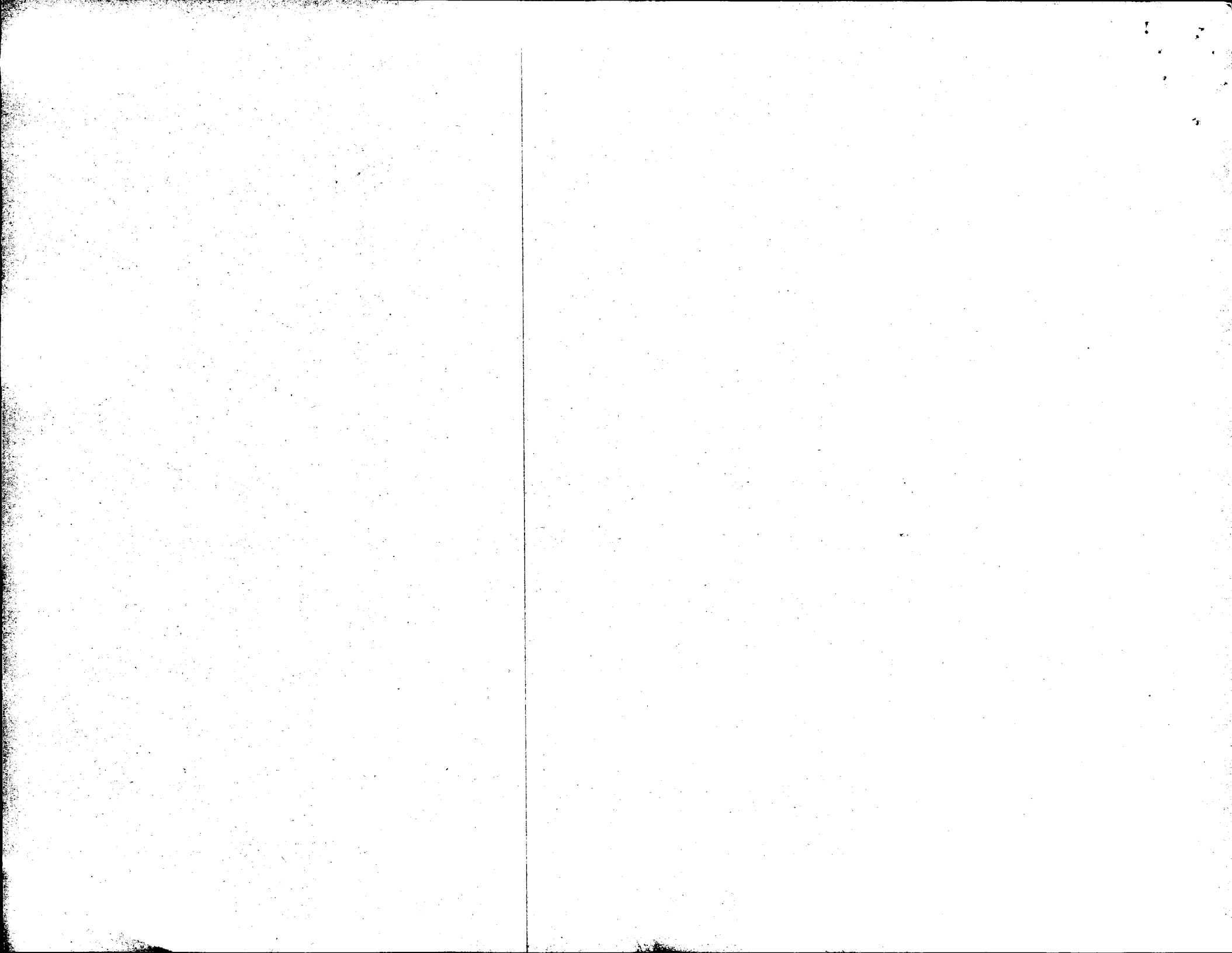
Memo

0.00

Thermoforming Machine

1-Machine Set-Up  
2-Pre-heat Tool to required temp.  
3-Thermoform as per Dwg and Folio #FTA059 using tool DT9343  
Dwg Rev: DT9344  
Folio Rev: DT9344

BB 09/07/13 X1



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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	QC2- Inspect parts off machine FAI/FAIB	0.00	DL 09/07/16 (X1)						
QC Quality Control	Memo Visually inspect part for proper formation and texture	0.00							
130 	QC8- Inspect parts - second check	0.00	DL 09/07/16 (X1)						
QC Quality Control	Memo	0.00							
140 	Hand Thermo	0.00	DL 09/07/16 (X1)						
Hand Finishing Thermoforming	Memo 1-Trim to finished dimensions as per Dwg	0.00							







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Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*09.07.20 Prototype*





# Picklist Print

Page 1

July 10, 2009 2:45:35 PM

Work Order ID: 50496

Parent Item: D3831-2KIVRevA-PROTO

Parent Item Name: Rear Overhead, RH

Comments:

Start Date: 07/13/2009

Required Date: 07/17/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased	No			100	sf	894.5038	11.0940			



6185 SYDEX .080"



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

109703

894.5037653

894.503765

BB 09/07/13 (X1)  
M109703



DART AEROSPACE LTD	Work Order: 50496
Description:	Part Number: D3831-2RIV
Inspection Dwg: D3831-2 Rev: A Proto	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"				
Shape Definition				
Texture Retention				
Material imperfections such as bumps, cracks, voids, scratching				

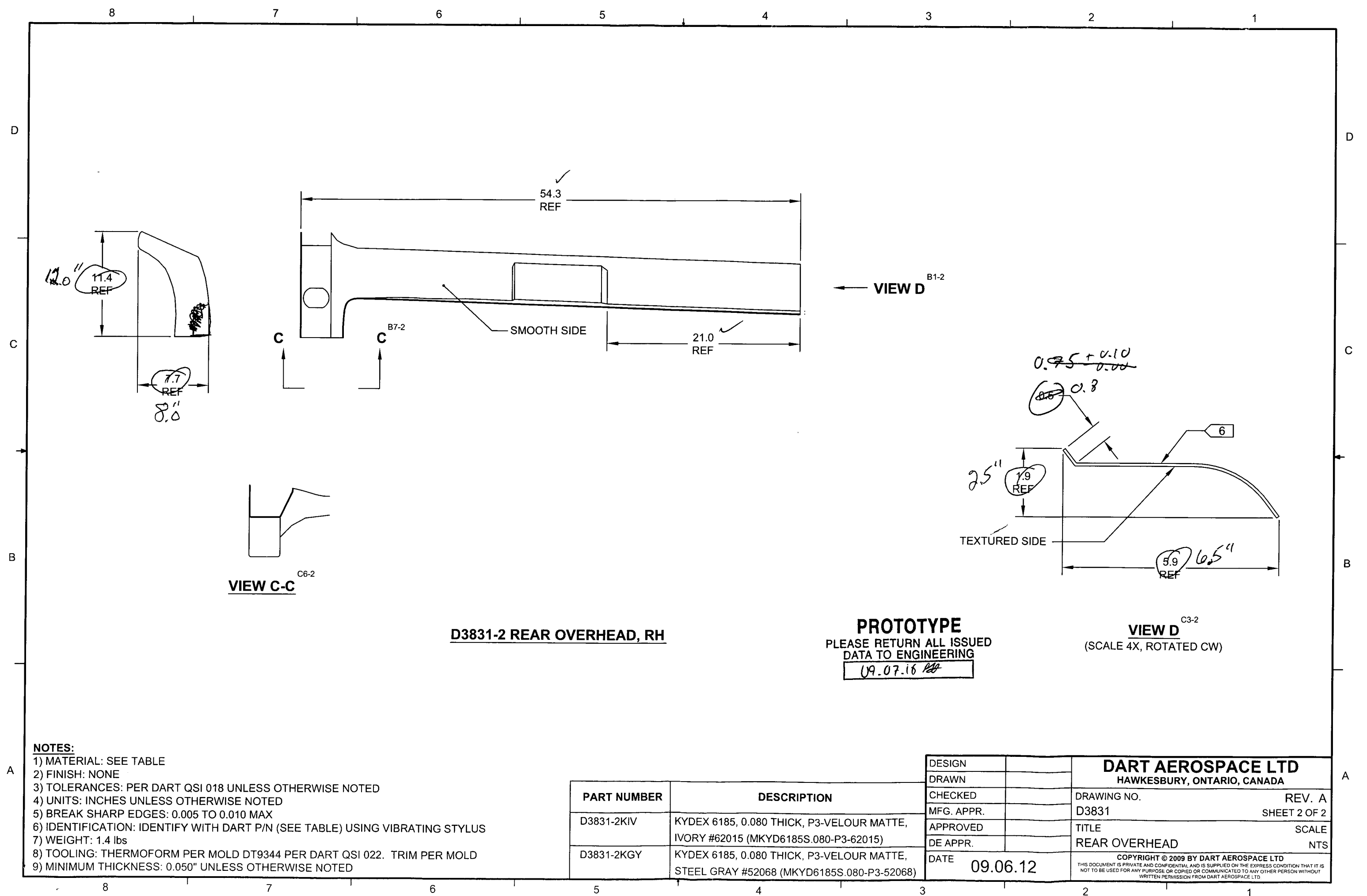
Measured by:	Date:
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### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.0"	Ref	12.0"	✓			
8.0"	Ref	8.0"	✓			
54.3"	Ref	54.3"	✓			
21.0"	Ref	21.0"	✓			
0.8"	±.100	0.75"	✓			
2.5"	Ref	2.5"	✓			
6.5"	Ref	6.5"	✓			
0.050"	±.010	0.053"	✓			
<del>0.030"</del>	Ref	<del>0.030"</del>	✓			
0.040"	Ref	0.045"	✓			

Measured by: Wheeler	Date: 09/07/16
Audited by: RU	Date: 09.07.12
Prototype Approval: RU	Date: 09.07.12

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	



- NOTES:**
- 1) MATERIAL: SEE TABLE
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
  - 7) WEIGHT: 1.4 lbs
  - 8) TOOLING: THERMOFORM PER MOLD DT9344 PER DART QSI 022. TRIM PER MOLD
  - 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3831-2KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3831-2KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3831	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		REAR OVERHEAD	NTS
DATE	09.06.12	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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